

Work Order ID 126896***126896***

Page 1

Monday, December 01, 2014 8:12:56 AM

Item ID: D350-689-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-12-01 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3022	B								
D3023	A								
IIN D350-689	B								

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels as per PPP D350-689-041 CHG002

N/A

105

Large Fab

0.00

105

Large Fab

Memo

0.00

Large Fab

1-Bend D3023-1 form edge of back pan as per dwg D3023 using D3017-041 back frame
2- Bend D3022-1 as per dwg1 R 12-12-14

Work Order ID 126896

126896

Page 2

Monday, December 01, 2014 8:12:56 AM

Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Dual High Back Seat Assembly

Stop

NS2

Start Date: 12/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

① 14-12-08 DAS 9 9-89

112

0.00

112

Large Fab

Memo

0.00

Large Fab

1- Transfer drill Seat Pan From Frame
Transfer drill in D3022-1 using D3017-041

2- Deburr

3- Assemble as per IIN 350-689-041

1 EL 14-12-14

114

QC5- Inspect part completeness to step on W/O

0.00

114

QC

Memo

0.00

Quality Control

① 14-12-08 DAS 9 9-89

Work Order ID 126896

126896

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Monday, December 01, 2014 8:12:56 AM

Item ID: D350-689-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Chemical Conversion Coat per QSI005 4.1	0.00							
115									
HandFinish	Memo	0.00				1	FF		DEC 08 2014
Hand Finishing	Chemical Conversion Coat only D3023-1 and D3022-1								

117	QC7-Inspect Chemical Conversion Coat	0.00							DAS 9 9-89
117									
QC	Memo	0.00				2	14-12-03		
Quality Control									

118		0.00							
118									
Small Fab	Memo	0.00				1X			14/12/08 DAS 36 9-89
Small Fab	Assemble back panel to back frame as per dwg								

2000

100

100

100

100

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Monday, December 01, 2014 8:12:56 AM

Item ID: D350-689-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Dual High Back Seat Assembly

Stop ***NS2***

Start Date: 12/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
119	QC5- Inspect part completeness to step on W/O	0.00							
119									
QC	Memo	0.00							
Quality Control									

① 14-12-03 70

120 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

120

Powdercoat

Memo

0.00

Powder Coating

Powder coat

START TIME: 8:20OVEN TEMPERATURE: 320FINISH TIME: 8:501 6 14-12-9 238

130 QC3- Inspect Part Finish 0.00

130

QC

Memo

0.00

Quality Control

14/12/09 36 8-89

0.

!

1268.96

Page 5

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 12/1/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Large Fab

0.00

Small Fab

Memo

Small Fab

Assemble frames and seat and back pan as per IIN-D350-689 page 15

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

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Monday, December 01, 2014 8:12:56 AM

Item ID: D350-689-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14/12/10
WF
14-12-9

Picklist Print

Monday, December 01, 2014 8:13:01 AM

Page 1

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
IPP Rev:I As per NCR 070 06-09-06 JLM
per DSI 9498 DD 10.02.12 verified by:JLM

IPP Rev:J as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20600-AD4W2

Purchased

No

Each

1,283.000

40

MS20600-AD4W2

**

Rivet

14/12/08
DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

776

m126475

776

ST309

407

125578

7

m125708

400

WA003

100

m126475

100

6

MS20600-AD4W3

Purchased

No

Each

1,187.000

MS20600-AD4W3

**

Cherry Rivets

14/12/08
DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

600

m129795

600

ST309

520

m130018

520

WA003

67

m127476

7

m129278

60

6

Picklist Print

Monday, December 01, 2014 8:13:02 AM

Page 2

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

D3022-1

Manufactured No

100

Each

6.0000

1

1

D3022-1

Seat Pan

**

Q 14-12-1

Location

Loc Qty

Loc Code

WA001

6

125400

1

125401

2

125841

1

~~126025~~

1

126274

1

D3023-1

Manufactured No

100

Each

2.0000

1

1

D3023-1

Back Panel

**

Q 14-12-2

Location

Loc Qty

Loc Code

WA001

2

124125

1

~~125745~~

1

D3016-041

Manufactured No

114

Each

0.0000

1

1

D3016-041

Seat Frame Assembly

122988x1

**

Q 14-12-2

D3017-041

Manufactured No

114

Each

0.0000

1

1

D3017-041

Seat Back

**

Q 14-12-2

125745

~~122988x1~~

Picklist Print

Monday, December 01, 2014 8:13:02 AM

Page 3

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

AN3-12A

Purchased

No

140

Each

186.0000

3

3

DAS
36
9-89

AN3-12A

Bolt

Location

Loc Qty

Loc Code

CA

5

m129682

5

GA

20

m128398

20

ST349

161

m130566

161

D3021-041

Manufactured

No

140

Each

0.0000

1

1

D3021-041

Tube/Assembly

D3024-1

Manufactured

No

140

Each

11.0000

3

3

D3024-1

Spacer

Location

Loc Qty

Loc Code

ST015

11

111838

11

D3028-1

Manufactured

No

140

Each

34.0000

4

4

D3028-1

Stud

Location

Loc Qty

Loc Code

ST015

34

109929

14

124022

20

Picklist Print

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Page 4

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

D3029-1

Manufactured No

140 Each

30.0000 2 2

14/12/09

DAS
36
9-89

D3029-1

Spring

Location

Loc Qty

Loc Code

GA

30

122745

30

2

Manufactured No

140 Each

10.0000 2 2

14/12/09

DAS
36
9-89

D3030-1

Lock

Location

Loc Qty

Loc Code

ST015

10

111519

5

116996

5

2

Manufactured No

140 Each

23.0000 2 2

14/12/09

DAS
36
9-89

D3031-1

Loop

Location

Loc Qty

Loc Code

GA

23

110906

2

124064

20

79747

1

2

Picklist Print

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Page 5

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

✱

MS21042L3

Purchased

No

140

Each

1,390.000

17

17

MS21042L3

14/12/09

DAS
36
9-89

Nut

Location

Loc Qty

Loc Code

FP001

500

M130922

500

ST305

890

123900

61

M127410

11

M127831

41

M128401

34

M128754

70

M130799

673

17

Picklist Print

Monday, December 01, 2014 8:13:03 AM

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Work Order ID: 126896

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

126896

D350-689-041

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

140

Each

4,203.000

6

6

MS21042I 4

Locknut

**

14/12/09 DAS 36 9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST260a

2000

m130799

2000

ST273A

709

m129934

709

ST305

1482

111827

2

126275

5

m126015

12

m126275

32

m127255

63

m127376

9

m127813

741

m128300

69

m129472

49

m130922

500

6

MS24693-S272

Purchased

No

140

Each

197.0000

4

4

MS24693-S272

SCREW

**

14/12/09 DAS 36 9-89

Location

Loc Qty

Loc Code

CA

48

M129682

48

ST292

149

M126119

15

M126190

134

4

Monday, December 01, 2014 8:13:03 AM

Shop Packet Print

Page 6

Picklist Print

Monday, December 01, 2014 8:13:03 AM

Page 7

Work Order ID: 126896

126896

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17

Purchased

No

140

Each

329.0000

4

4

MS27039-1-17

Screw (601.1954)

14/12/09
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

46

120142

46

ST273A

150

m127831

150

ST285

133

124326

1

m127305

132

4

***MS27039-1-19**

Purchased

No

140

Each

616.0000

6

6

MS27039-1-19

Screw

14/12/09
DAS
36
9-89

Location

Loc Qty

Loc Code

ST273A

556

m127904

556

ST284

60

125654

60

M124326
(6x)

MS27039-4-21

Purchased

No

140

Each

54.0000

6

6

MS27039-4-21

Screw

14/12/09
DAS
36
9-89

Location

Loc Qty

Loc Code

ST284

54

m127904

4

m129909

50

6

Picklist Print

Monday, December 01, 2014 8:13:03 AM

Page 8

Work Order ID: 126896

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

126896

D350-689-041

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

140

Each

2,001.000

17

17

NAS1149D0332.J

Washer

**

14/12/07

DAS
36
9-89

Location

Loc Qty

Loc Code

CA

33

m129682

33

ST260a

1755

m130325

1755

ST269

213

m128606

14

m128612

174

m129624

25

17

NAS1149D0432J

Purchased

No

140

Each

30.0000

6

6

NAS1149D0432.J

WASHER

**

14/12/07

DAS
36
9-89

Location

Loc Qty

Loc Code

ST269

30

124580

7

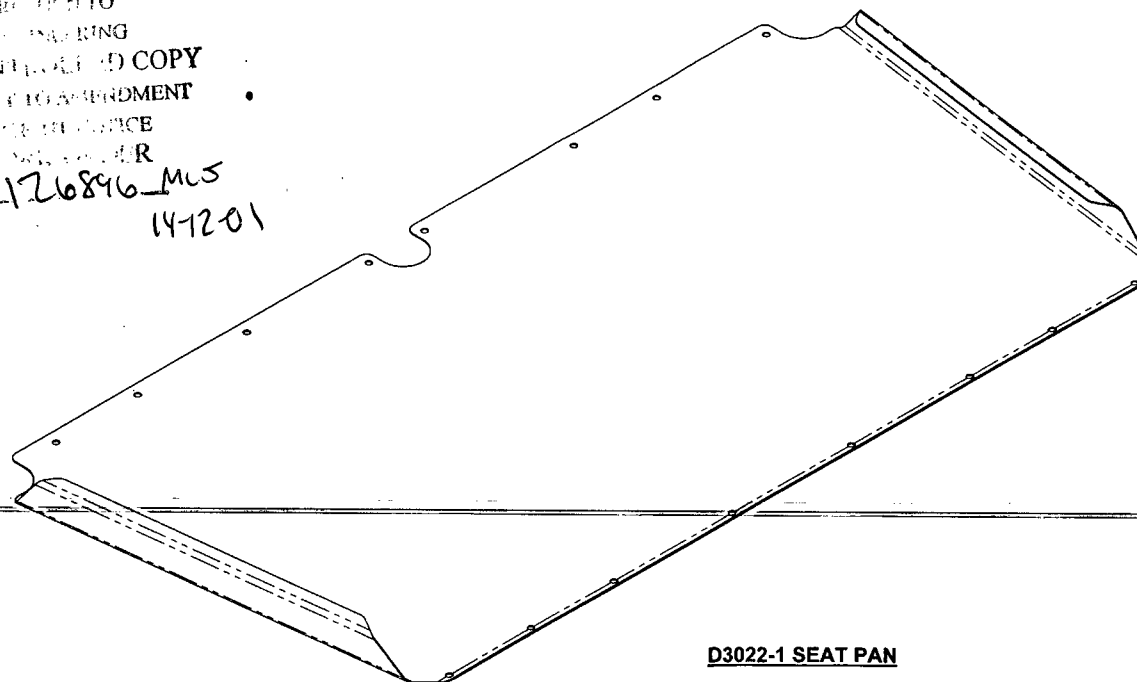
125578

23

M131026

(6x)

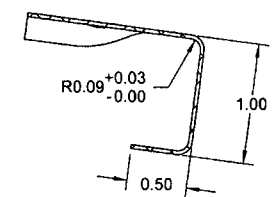
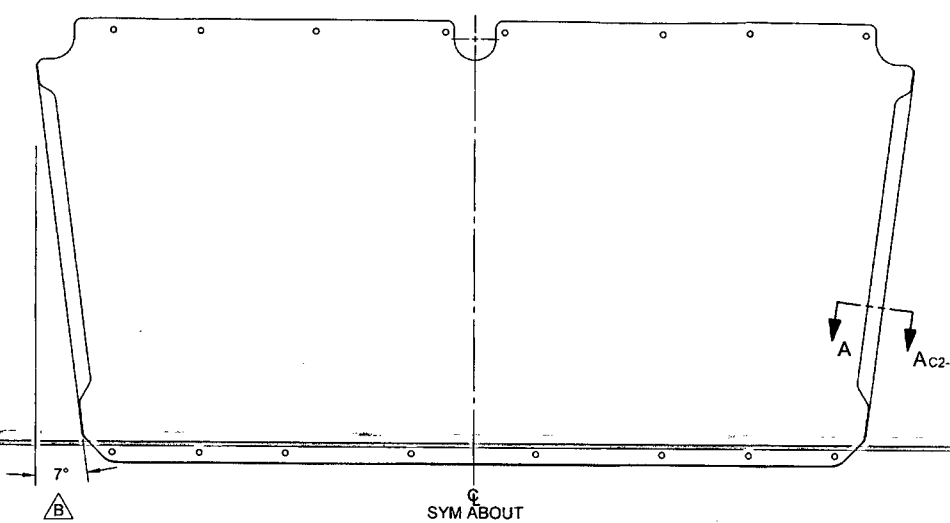
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 BY THE OFFICE
 OF THE DRAWER
 NO. 126896-MCS
 147201



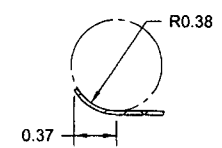
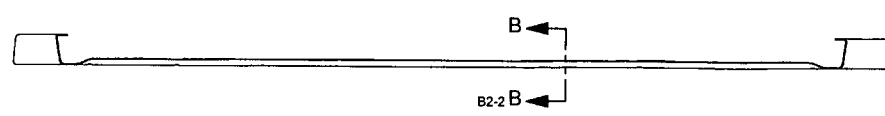
D3022-1 SEAT PAN

RELEASED
08/12/15 W

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED, D7-3 12.075 WAS 12.325, D8-3 9.175 WAS 9.425 & D9-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 TITLE SEAT PAN SCALE NTS		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DATE 08.11.27 COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		



SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

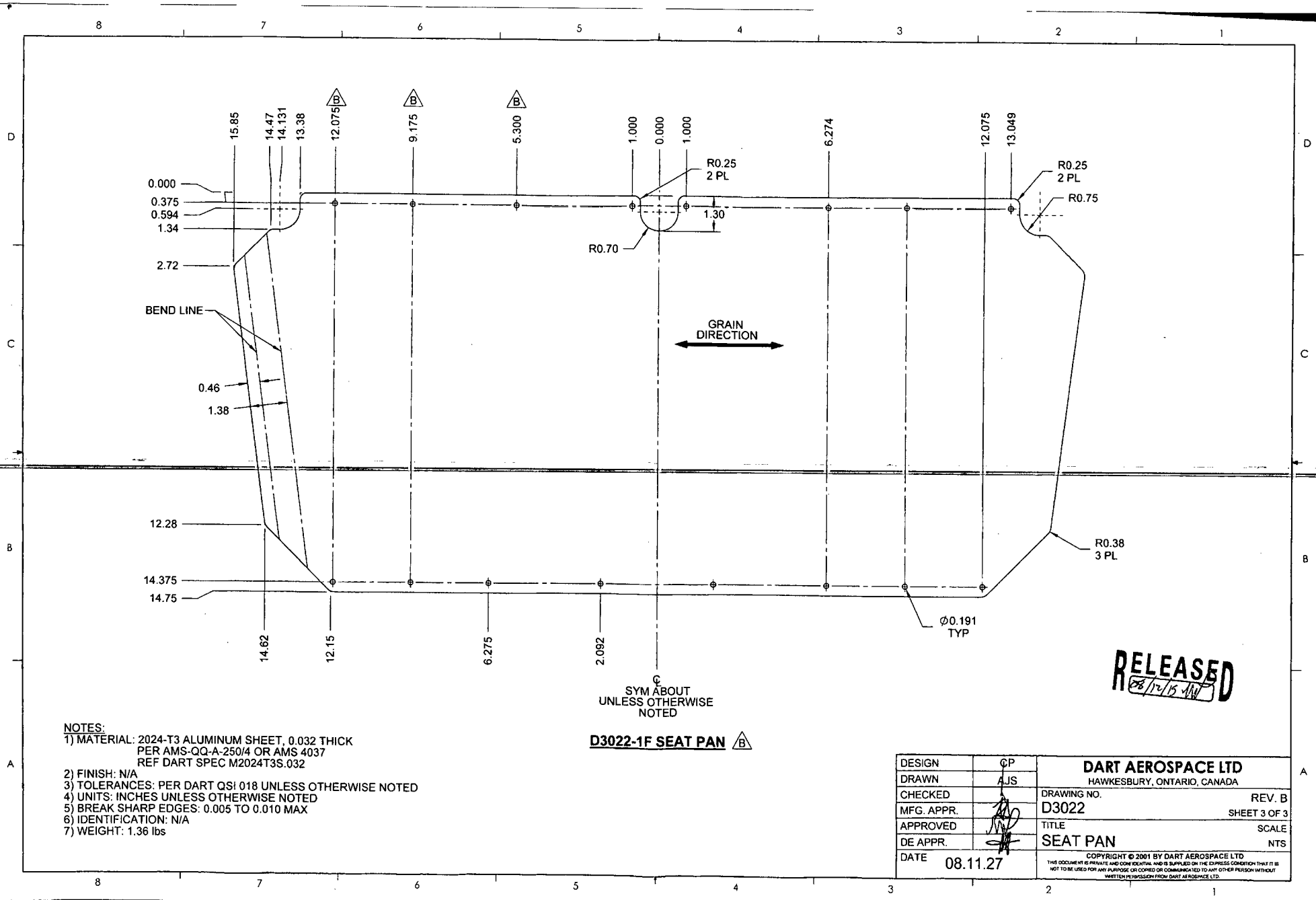
D3022-1 SEAT PAN

RELEASED
08/12/15

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



NOTES:

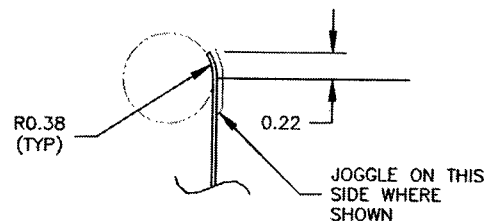
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN B

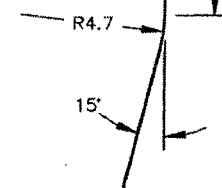
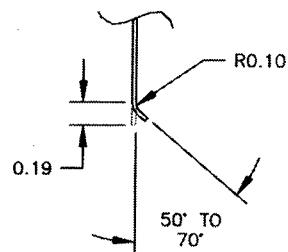
RELEASED
08/12/15 JAW

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

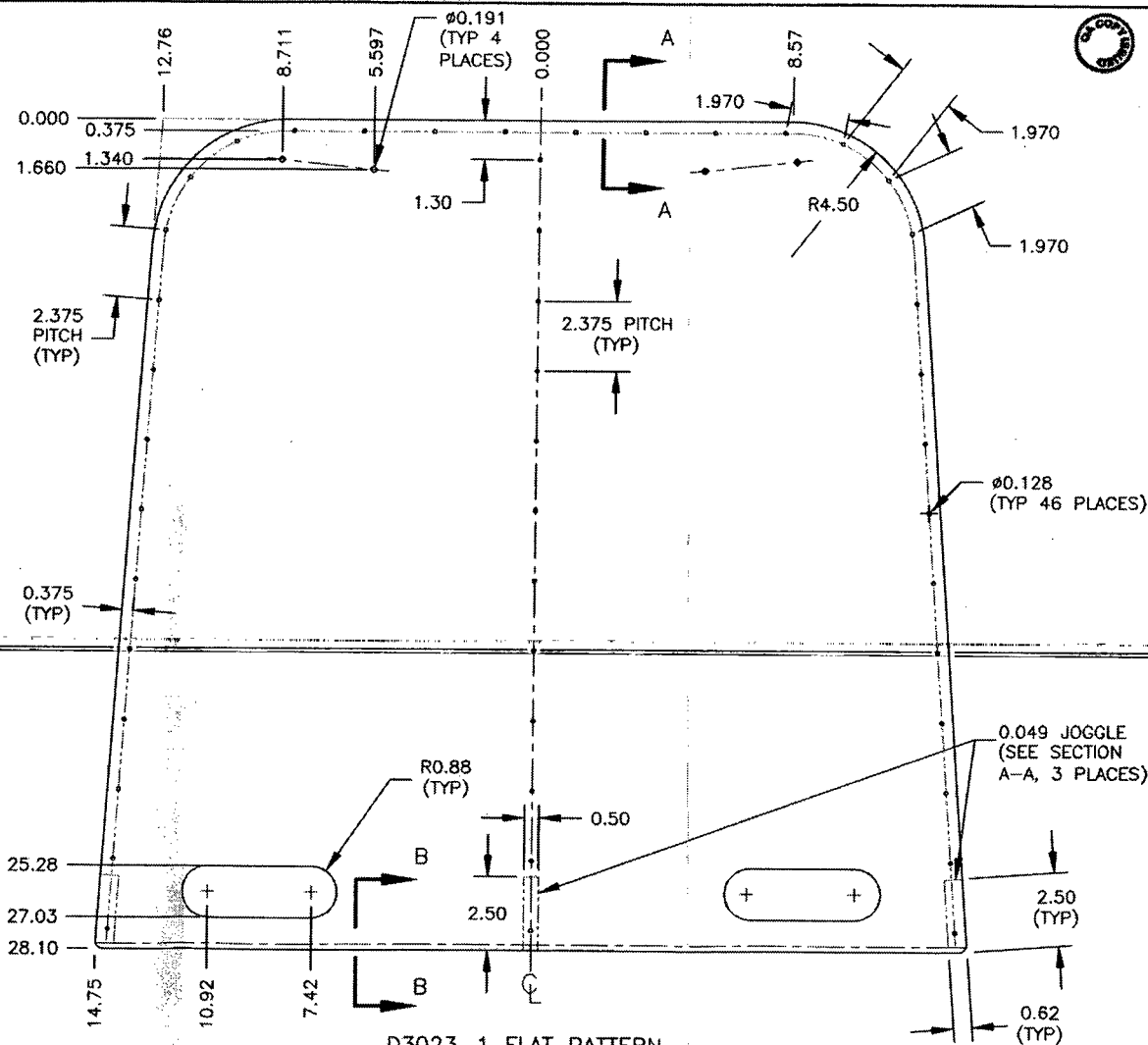
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM-EDGE-ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

RELEASED
9.06.07

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, ENGLAND
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

